

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 160086

Thursday, April 20, 2017 2:52:58 PM

160086

Page 2

Item ID: D350-567-113 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Exterior Super-sized Window
Start Date: 4/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/28/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-567-113 Location:FG032								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40							
Quality Control									

MAY 16 2017

17/5/16

MAY 16 2017

DAS
21
9-89

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Page 1

Work Order ID: 160086

160086

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 4/21/2017

Required Date: 4/28/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 04-08-24 New Issue JLM
IPP Rev:B 08-10-07 as per revD DD verified by: IPP REV:C
13.10.15 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DT8439		Manufactured	Yes			110	Each	0.0000	1	4			
--------	--	--------------	-----	--	--	-----	------	--------	---	---	--	--	--

DT8439

TEMPLATE

D2463		Manufactured	No			110	f	185.5345	7.166	30.17263			
-------	--	--------------	----	--	--	-----	---	----------	-------	----------	--	--	--

D2463

1/2" Seal (\$ per foot)

Location

Loc Qty

Loc Code

ST409

185.5344587

140013

3.9081E-05

148875

185.53442

1x (D2463-0860 as per dwg) CUT TO 86.00"

D3290-041		Manufactured	No			110	Each	4.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3290-041

Replacement Exterior Window For -111

Location

Loc Qty

Loc Code

ST433

4

155499

4

2600-6		Purchased	No			110	Each	141.0000	12	48			
--------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

2600-6

Camlock Stud

Location

Loc Qty

Loc Code

ST580

141

M136648

41

M136986

50

M137280

50

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 160086

160086

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 4/21/2017

Required Date: 4/28/2017

Start Qty: 4.00

Required Qty: 4.00

2600-LW Purchased No

110 Each 209.0000 12 48

2600-LW

Washer, Camlock Retaining

**

DAS
6
9-89

MAY 15 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST580

209

m136295

59

m137280

150

212-12 Purchased No

110 Each 132.0000 12 48

212-12

Receptacles

**

DAS
6
9-89

MAY 15 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST577

132

M136648

32

M136866

50

M137280

50

AN526C832R9 Purchased No

110 Each 302.0000 21 84

AN526C832R9

Screw

**

DAS
6
9-89

MAY 15 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

over006

200

M136983

200

ST327

102

M134962

102

NAS1149DN832J Purchased No

110 Each 750.0000 42 168

NAS1149DN832J

Washer

**

DAS
6
9-89

MAY 15 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

750

M135297

750

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY							
Environment	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
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Tribal Knowledge	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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Past Expiry Date	☐	OTHER : _____							
Misidentified	☐								

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Work Order ID: 160086

160086

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 4/21/2017

Required Date: 4/28/2017

Start Qty: 4.00

Required Qty: 4.00

MS21042L08

Purchased

No

110

Each

390.0000

21

84

MS210421 08

Nut

**

DAS

6

9-89

MAY 15 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

214

m135974

18

m135978

196

ST303

176

m137320

176

MS20426AD3-5

Purchased

No

110

Each

3,374.000

24

96

MS20426AD3-5

Rivet

**

DAS

6

9-89

MAY 15 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

2304

4533

2304

ST312

1070

4533

1070

FG-778150-550-ROL

Purchased

No

110

sf

832.5000

18

96

*FG-778150-550-ROI *

7781 9 oz Glass 50" x 125 yd

**

DAS

6

9-89

MAY 15 2017

DAS 28 9-89

Location

Loc Qty

Loc Code

CA2

832.5000450

M127701

4.4850E-05

M134550

832.500000

2sq yards

DAS 27 9-89

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Description Work Order Deviation				Disposition				Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

REFERENCE ONLY

D350-567

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DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury, ON, K6A 1K7
CANADA

Tel: 1 613 632 5200

Fax: 1 613 632 5246

e-mail: heli@dartaero.com

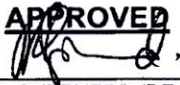
<http://www.dartaero.com>

INSTALLATION INSTRUCTIONS

D350-567

Vertical Reference Window Installations

EUROCOPTER AS 350/355 MODELS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	13.08.15
CERT. NO.:	SH92-18
ISSUE NO.:	#6

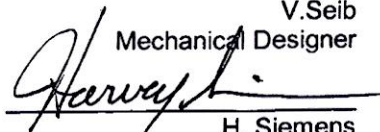
Prepared By:



V. Seib

Mechanical Designer

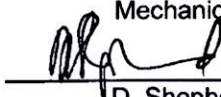
Checked By:



H. Siemens

Mechanical Designer

Released By:



D. Shepherd, P. Eng.
Chief Engineer

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Revision: E

Date: 13.08.15

